

Work Order ID 58957

Thursday, May 20, 2010 11:05:34 AM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID:

Item Name: 350 Basket Base

Stop



Start Date: 5/20/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10-5-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2221

Rev H

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221 *PD*
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per *PD*
dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: *M108175*

PD 10.05.31

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

QC 10.05.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

8 10/05/31

①

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

27 10/05/31

1

Powder Coating

C1- Plug holes prior to

1ST COAT:

START TIME: 1:00pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 1:30pm

***** 2nd coat if necessary *****

2ND COAT:

START TIME: 2:00pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 2:30pm

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

GB 10/06/01 @

150

Identify as per dwg & Stock Location: *G-A*

0.00



Packaging

Memo

0.00

Packaging

*u/a 58956**GB 10/06/01 @*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/06/01 DJ**CL 10/6/11*

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Picklist Print

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Page 1

Work Order ID: 58957

Parent Item: D2221

Parent Item Name: 350 Basket Base









Start Date: 5/20/2010

Required Date: 5/31/2010

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM
IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2221-1	Manufactured	No	100	Each	23.0000	1	
							 PD 10.05.21
Rib							
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
		WA		23			
		57182		1			
		57499		10			①
		58122		12			
D2221-5	Manufactured	No	100	Each	16.0000	2	
							 PD 10.05.21
Rib							
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
		WA		16			
		57500		8			②
		58027		8			
D2221-7	Manufactured	No	100	Each	8.0000	1	
							 PD 10.05.21
Rib							
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
		WA		8			
		57501		4			①
		57805		4			
D2232-3	Manufactured	No	100	Each	14.0000	2	
							 PD 10.05.21
Basket Hinge							
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
		WA		14			
		57502		8			②
		57793		6			

W/O:		WORK ORDER CHANGES					
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IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2235-1 Manufactured No 100 Each 12.0000 2



Basket Rib



PD 10.05.21

Location Loc Qty Loc Code

WA 12

57593 2

57792 10

D2581 Manufactured No 100 Each 44.0000 2



Mounting Bracket



PD 10.05.21

Location Loc Qty Loc Code

WA 44

46086 2

51745 2

57185 1

58301 19

58687 20

D3442-1 Manufactured No 100 Each 28.0000 2



Shim



PD 10.05.21

Location Loc Qty Loc Code

WA 28

56579 16

58028 12

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Shop Packet Print

Page 2

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 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3825-041 Manufactured No 100 Each 8.0000 2

 Rib Assembly (Basket End) PD 10.05.21

Location	Loc Qty	Loc Code
WA	8	
57401	2	
58025	6	(2)

D3826-041 Manufactured No 100 Each 8.0000 2

 Rib / Gusset Assembly PD 10.05.21

Location	Loc Qty	Loc Code
WA	8	
57432	2	
57835	6	(2)

D3827-041 Manufactured No 100 Each 10.0000 1

 Rib Assembly (Inboard) PD 10.05.21

Location	Loc Qty	Loc Code
WA	10	
57219	4	(1)
57802	6	

D3832-1 Manufactured No 100 Each 6.0000 1

 Mesh (Base) PD 10.05.21

Location	Loc Qty	Loc Code
WA	6	
57791	3	(L)
58165	3	

W/O:		WORK ORDER CHANGES					
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IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3833-1 Manufactured No 100 Each 9.0000 2



1D 10.05.27

Mesh (Base End Face)

Location

Loc Qty

Loc Code

WA

9

56396

1

57834

8

(2)

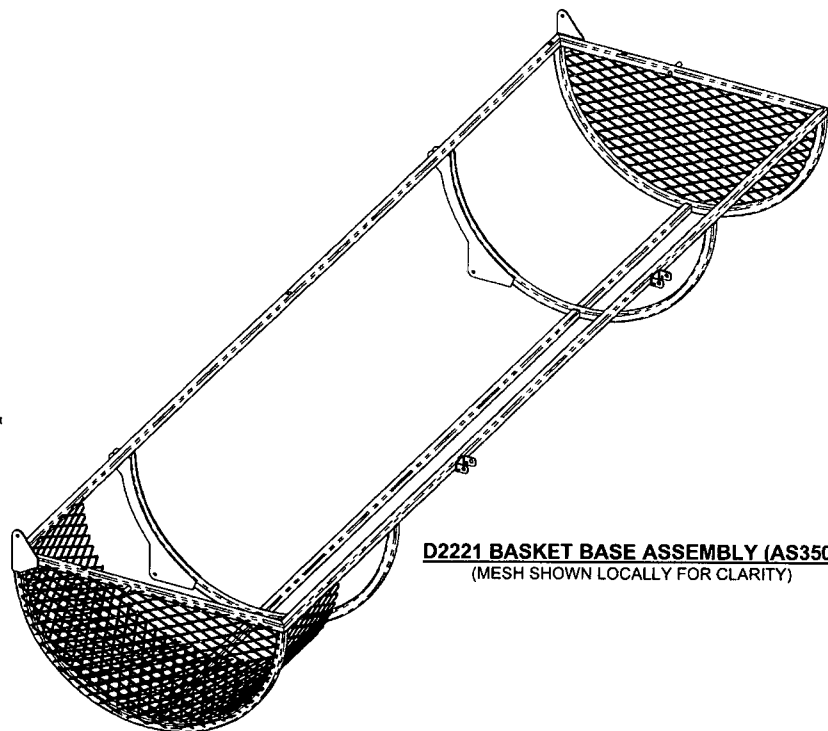
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NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 58957

R/W 5-20



ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BW		
CHECKED	AJS	DRAWING NO.	REV. H
MFG. APPR.	AJS	D2221	SHEET 1 OF 5
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

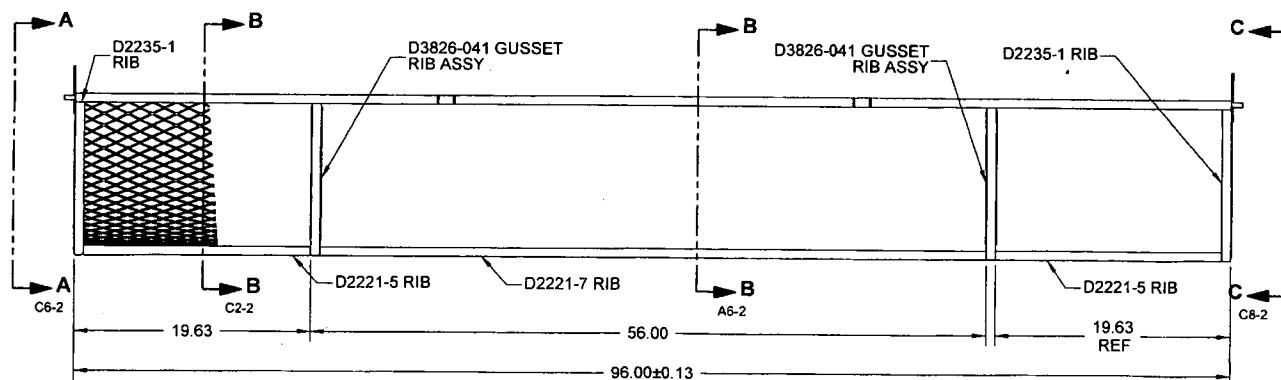
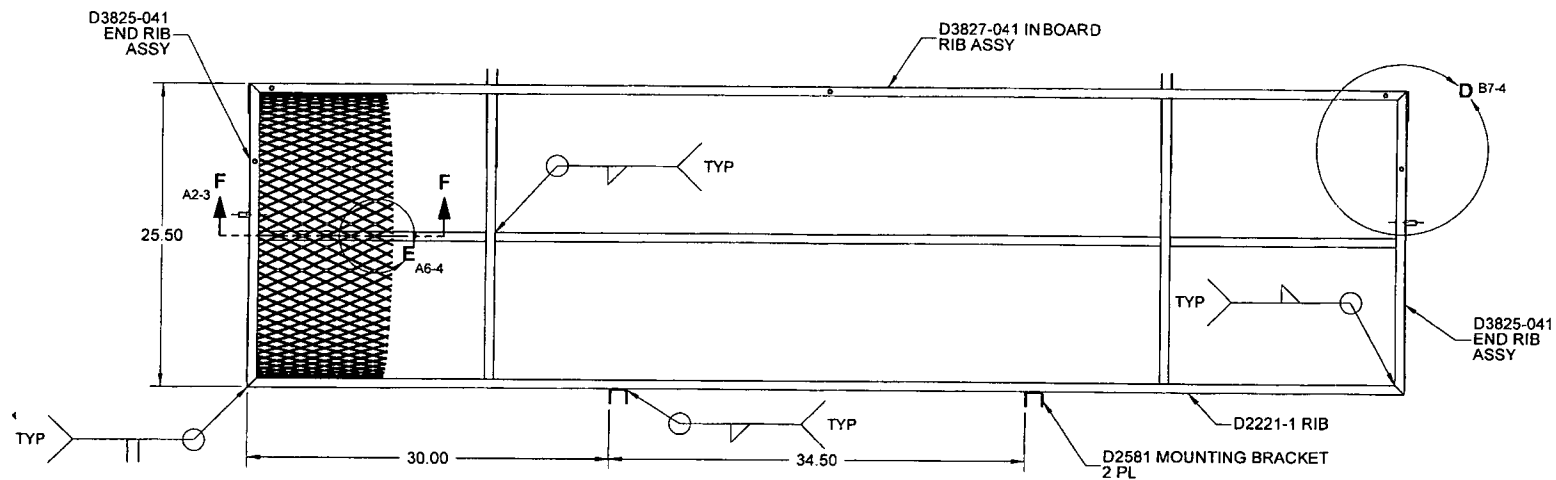
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
NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18 NCD

u/o 58957

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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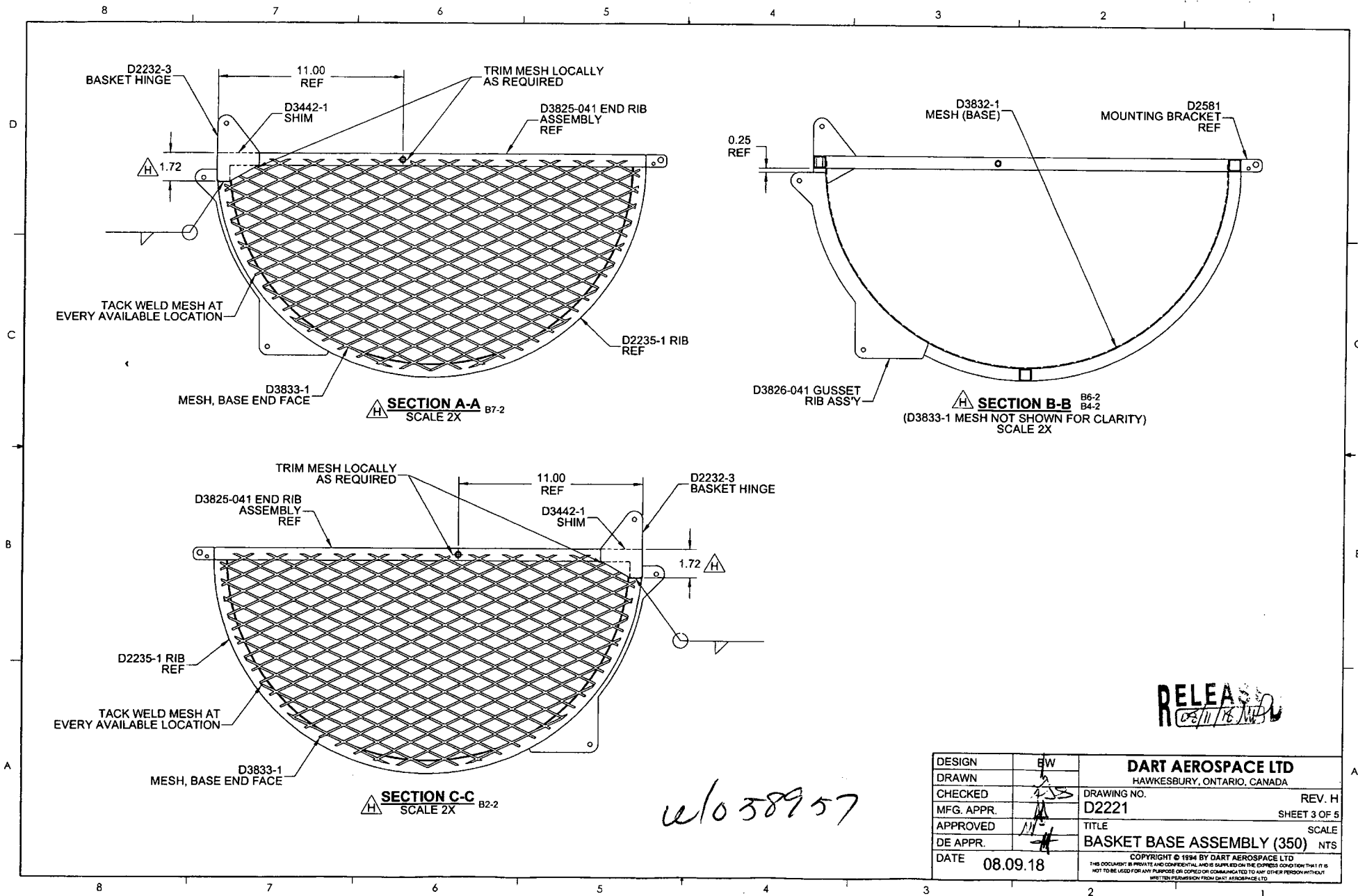
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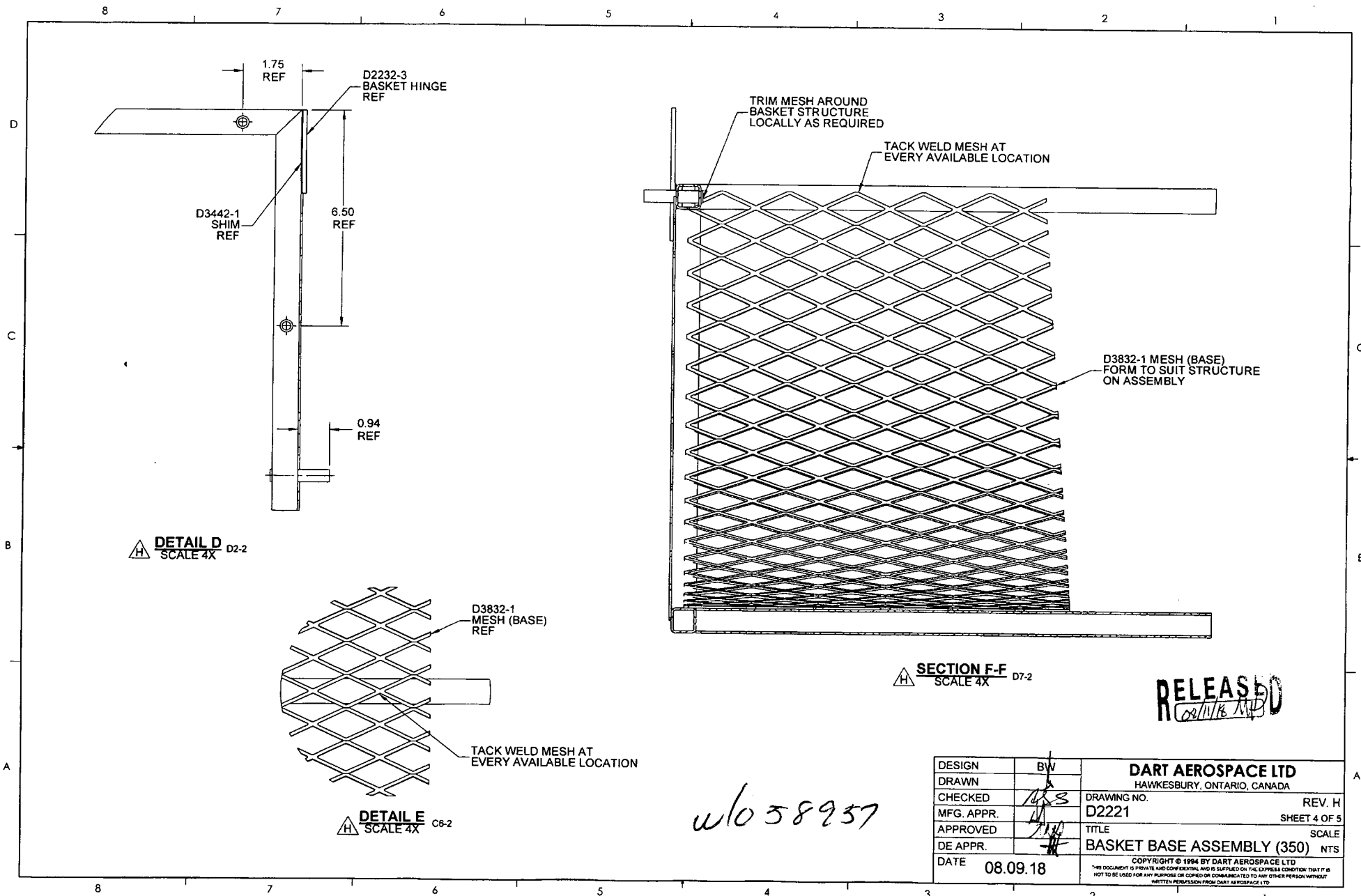
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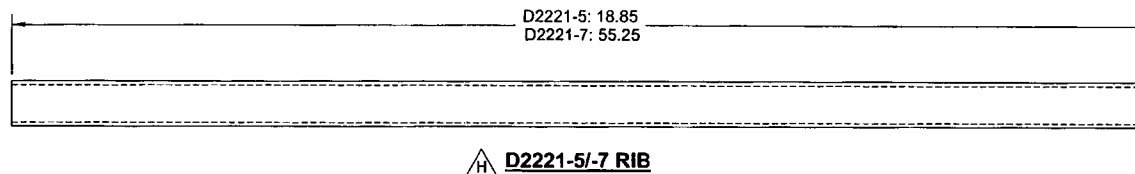
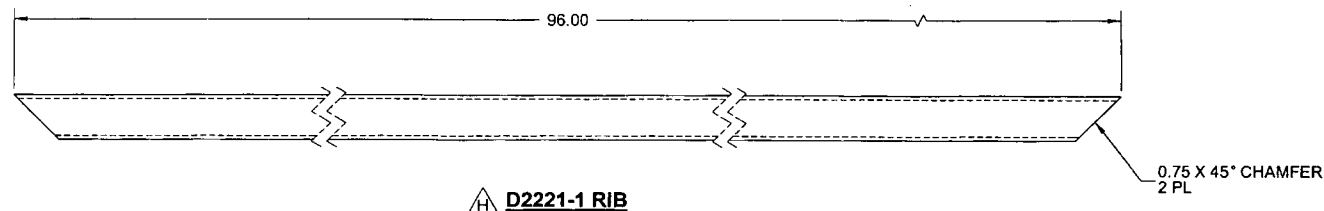
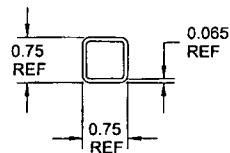
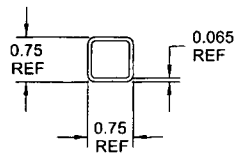
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RELEASED
08/10/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

WLO 58957

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNITED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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